

Date: Tuesday, 21/04/2009 1:12:18 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350/355 AS X-TUBE AFT
<b>Job Number</b> : 47329	
<b>Estimate Number</b> : 12486	
<b>P.O. Number</b> :	<b>Part Number</b> : D350748201
<b>This Issue</b> : 21/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 47085	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each

**Checked & Approved By** : JUD 09.04.21

**Comment** : Est Rev: A New Issue 06-07-05 JLM  
Est Rev: B Update qty of MS21042L5 06-09-12 KJ  
Est Rev C Combined manufacturing 08.04.02 EC verified by:  
DD  
Est Rev:D 08-06-24 revD as per dwg DD verified by:EC  
Est Rev: E 08.12.11 Step17 was step 21 KJ Verified by:

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** Photocopy bluefile & type labels per PPPD350-748-201 CHG001



2.0	D350748241TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
CROSSTUBE TURNING DETAIL  
batch B-45518

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE  
Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
Set-up drill table as per QSI 010

2-Deburr

87 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-101 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 09/06/11

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47329</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.04.27</u>	<u>3</u>	<u>Tube wide after bending</u>	<u>JP</u> <u>09.04.27</u> <u>pu</u> <u>08.04.22</u>	<u>Acceptable</u>	<u>MD</u> <u>09-24-29</u>	<u>S</u> <u>09/06/11</u>	<u>JP</u> <u>09.04.27</u>	<u>S</u> <u>09/06/11</u>

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 1:12:18 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47329

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-241 *2X 09-04-27*

4-Remove all marks from tube within limits of D350-748-241

*- 9-4-28 ANM*

5- Apply a light coat of LPS3 on the interior of tube

Batch: *B - 109956 ANM 9-4-29*

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*6 09/04/29 (4)*

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *8699*

*CL 09/04/30*

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

*(1)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

*04/05 (1)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*09/03/29 (1)*

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

*2X 09-06-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47329

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

*09-06-09*

12.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

✓ Abrasion Strip 7.10" long x2

Batch: 42437

*RT 09-06-09*  
*42437*

13.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Insert

Batch: 107441

*RT 09-06-09*

14.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Washer

Batch: 105442

*RT 09-06-09*

15.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ Clamp (per MIL-DTL-8783C)

Batch: 110936

*RT 09-06-09*

16.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Screw

Batch: 111425

*RT 09-06-09*

17.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ SUPPORT

Batch: 41603

*RT 09-06-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47329

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abraison strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

21 09-06-09

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-10 (12)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: 45668

88 09/06/10 (X)

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: 44637

88 09/06/10 (X)

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: M110399

88 09/06/10 (X)

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

bolt

Batch: M110363

88 09/06/10 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47329

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M111279 M111425

SS 09/06/10 (X)

26.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Batch:

M111279

SS 09/06/10 (X)

27.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch:

M111279

SS 09/06/10 (X)

28.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Batch:

M110507

SS 09/06/10 (X)

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch:

111127

SS 09/06/10 (X)

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/06/10 (X)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev:

A

SS 09/06/10 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47329

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11 [Signature]

Job Completion



mr 09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

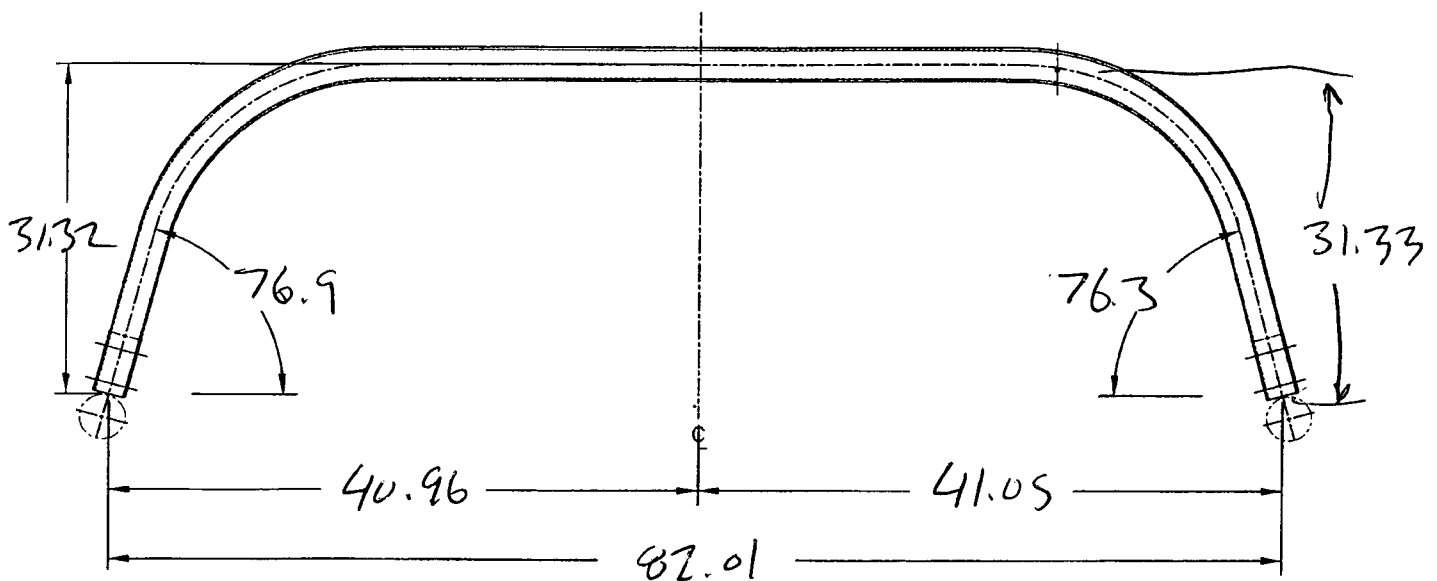
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	47329
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



TWIST DEFLECTION: 0.341"

Comments
TWIST IS OK <del>##</del> 09.04.27
WIDTH IS OK <del>##</del> 09.01.27

QC15 Inspection	<i>JP</i>
Date	09.04.27

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>AK</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**

06.10.31

DESIGN QP	DRAWN BY QP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STRIPLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

**UNDER REVIEW**09.02.05  
PER PCR 309-001

SHOP COPY

UNCONTROLLED COPY

WITHOUT NOTICE  
WORK ORDER

NO. 10321

**UNDER REVIEW**

07.02.16

CUT OFF 07.10.22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

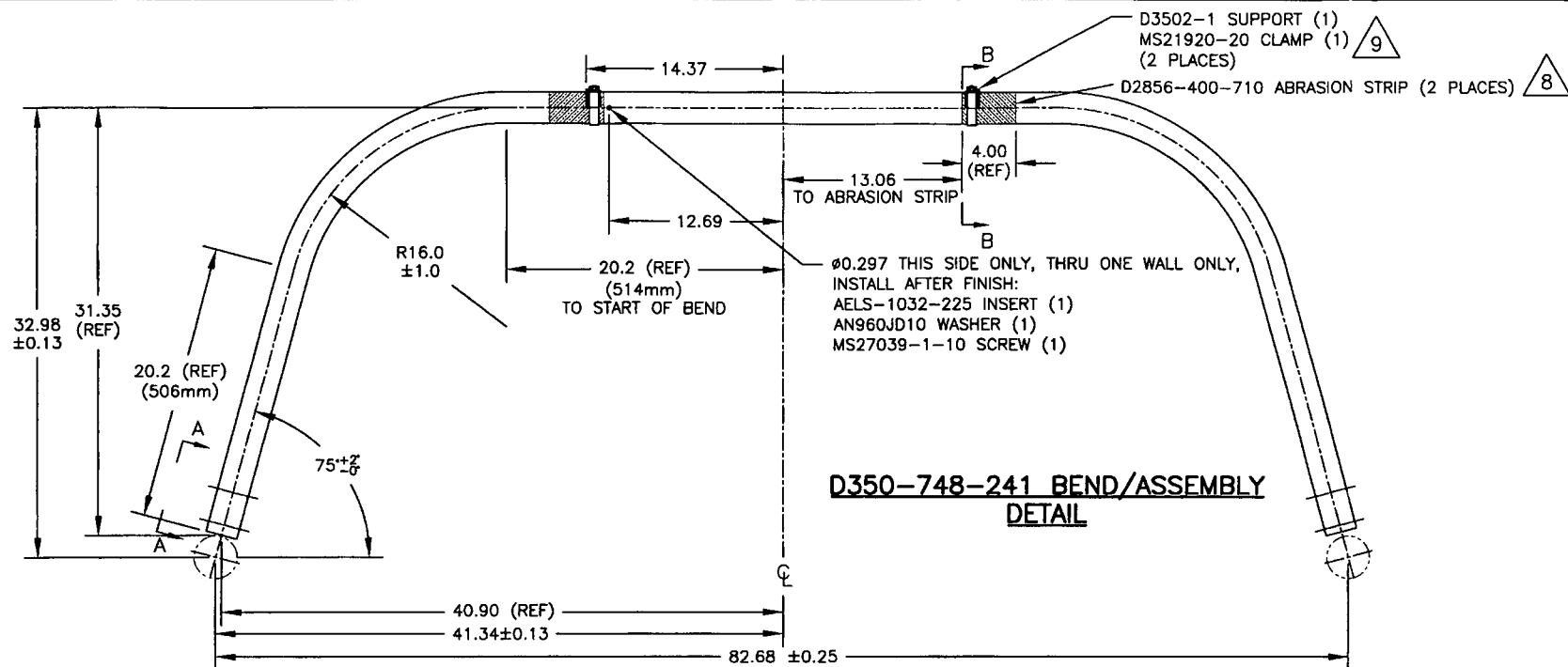
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

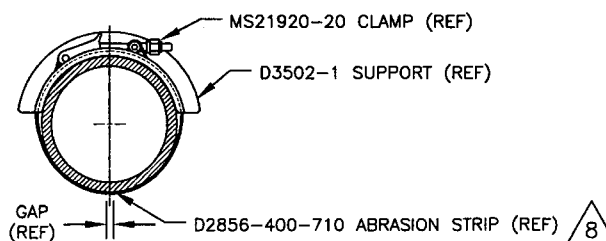
**NOTE:** Date & initial all entries



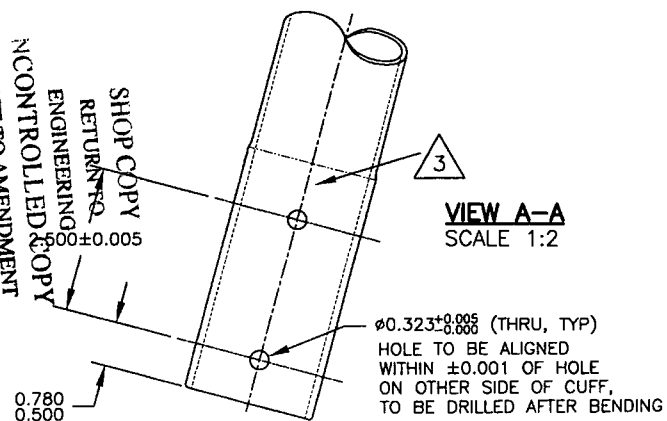


### D350-748-241 BEND/ASSEMBLY DETAIL

#### SECTION B-B SCALE 1:2



#### VIEW A-A SCALE 1:2



UNDER REVIEW

09.02.05

UNDER REVIEW

07.02.05

OK 10.10.02

RELEASED

06.10.31

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DESIGN

DRAWN BY

**DART**

DART AEROSPACE LTD.  
HAMMERSLEY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.  
D350-748-241

REV. D

DATE

TITLE

SCALE

06.10.31

CROSSTUBE (AS 350/355 HI AFT)

1:8

WORK ORDER  
WITHOUT NOTICE  
NCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**Dart Aerospace Ltd**

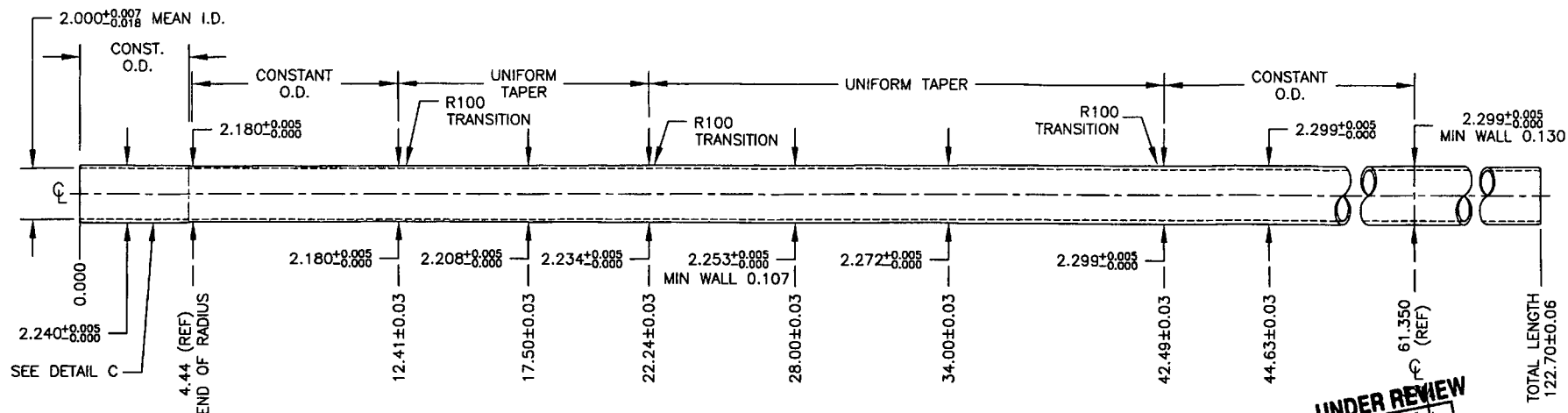
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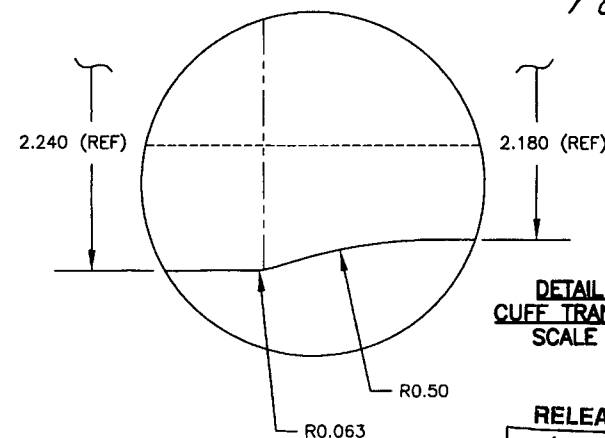
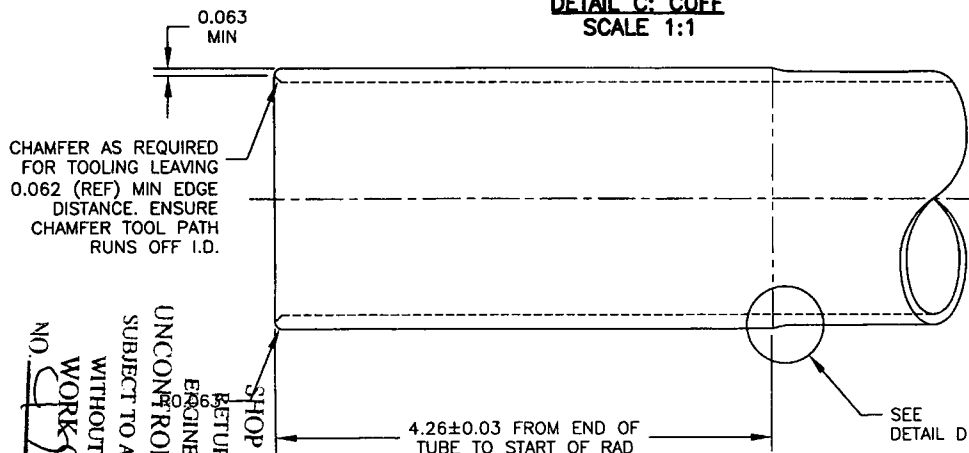


# D350-748-241 MACHINING DETAIL

UNDER REVIEW  
09.02.05

UNDER REVIEW  
09.02.05  
OK 06.21.22

## DETAIL C: CUFF SCALE 1:1



## DETAIL D: CUFF TRANSITION SCALE 9:1

RELEASED  
06.10.31

COPYRIGHT © 2006 BY DART AEROSPACE LTD.		DESIGN qp	DRAWN BY qp	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)			SCALE 1:4

NO. 1  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY  
4.26 ± 0.03 FROM END OF  
TUBE TO START OF RAD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** May-29-2009

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 86267  
**INVOICE #:** 44585

**CONTRACT OR  
PURCHASE ORDER #**

**PO00008699**

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** D350-748-201

**S/N #** B47329

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART #10438. MPI  
INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW AMS-QQ-P-  
416B, TYPE 2 YELLOW, CLASS 1. BAKE HEAT CHART #10492.**

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



A large, stylized handwritten signature in black ink.